

Date: Wednesday, 1/31/2007 2:59:23 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 30539	
Estimate Number : 12590	
P.O. Number : <i>N/A</i>	Part Number : D35604-
This Issue : 1/31/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3560 UNDER REVIEW <i>OK</i>
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 29450	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 2/7/2007
Checked & Approved By : <i>[Signature]</i> 07.02.01	Qty: <i>(4)</i> Um: Each
Comment : Est Rev:A New Issue 06-11-10 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1 f(s)/Unit Total: 1 f(s)

6061-T6 Bar .50" x 6.0"

Batch: *M103435**M 07 02 13**(4)*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3560

Dwg Rev: *A*Prog Rev: *A**M 07 02 13**(4)*

2-Deburr if necessary

Note: .507" Dia &amp; .196" Dia Holes are to opened on manual mill after Waterjet

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*M 07 02 14**(4)*

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1-Open .196" Dia hole

2-C'Bore as per Dwg D3560.

3-Ream .507" as per Dwg D3560

\*\*\*Ensure to C'Bore on Corect side\*\*\*

*DISP 07/02/17 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/02/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:59:24 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 30539

Part Number: D35604

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DSP 07/02/17 (4)*

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*ML 07/02/17*

*4*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *St*

*CP 07/02/18 (4) (4)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(4) 07/02/21*

Job Completion



*U 07-02-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

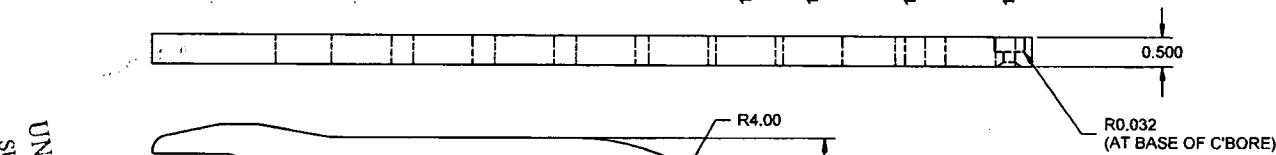
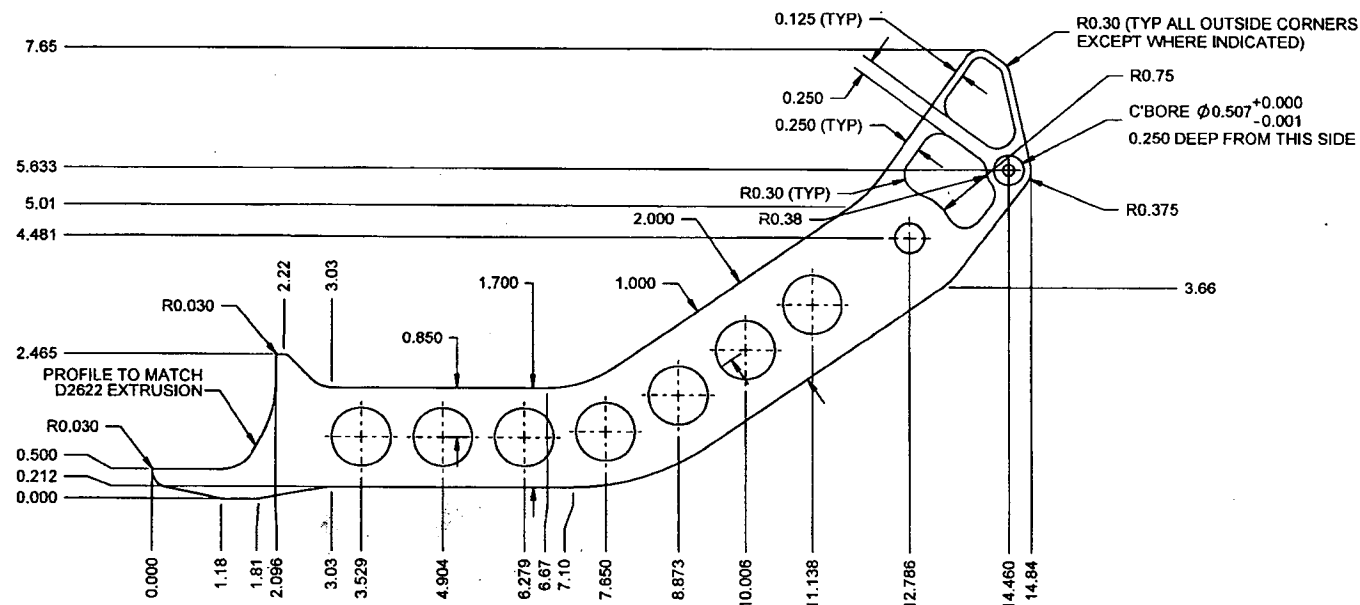
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



NO. 30539  
WORK ORDER  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

**D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)**

- NOTES:
- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11), 0.500 THICK (REF DART SPEC. M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS

**UNDER REVIEW**

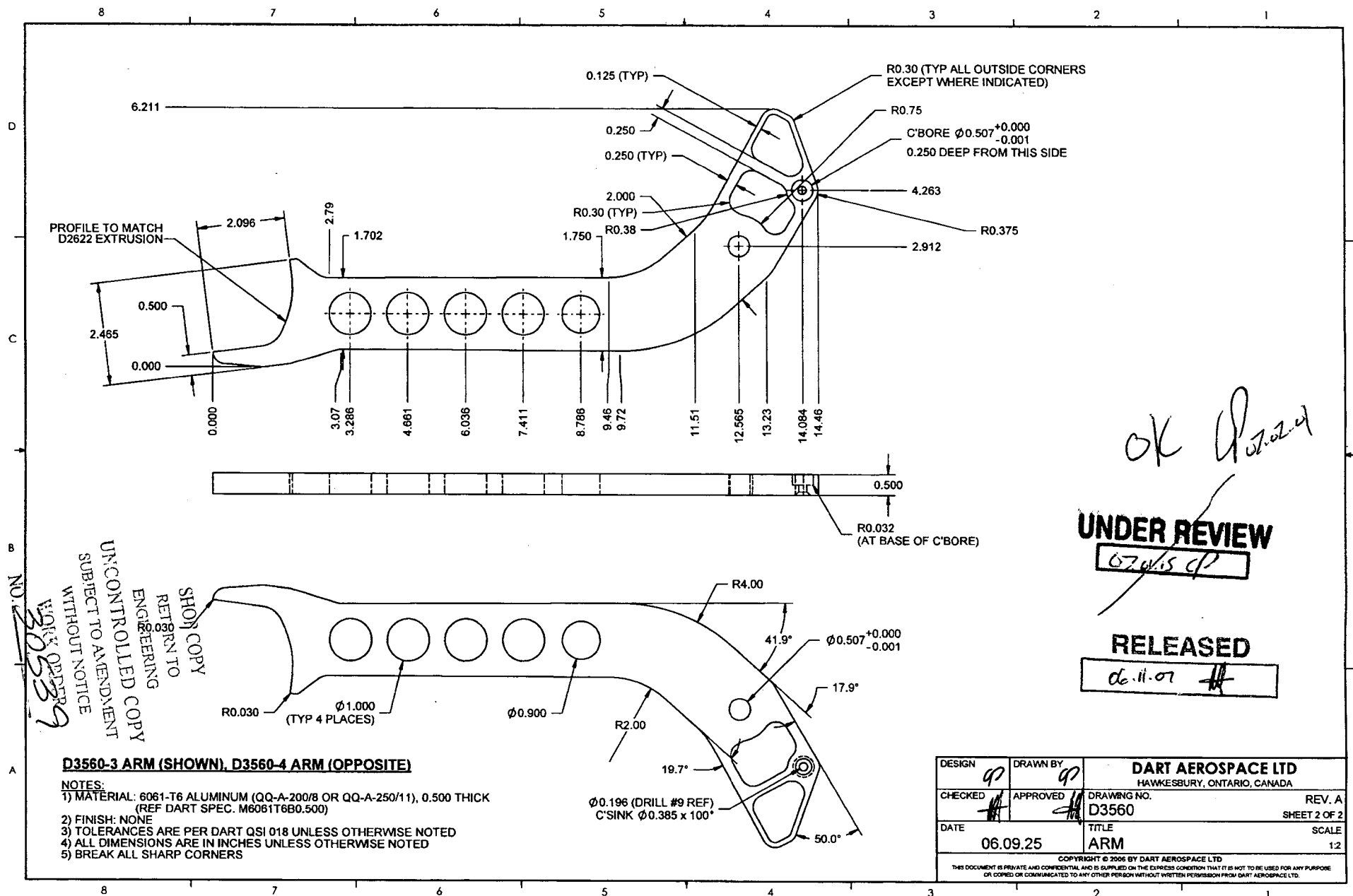
07.01.15 97

For re-design

**RELEASED**

06.11.07

A	06.09.25	NEW ISSUE
DESIGN	90	DRAWN BY 90
CHECKED	11	APPROVED 11
DATE	06.09.25	TITLE ARM
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
		DRAWING NO. D3560
		REV. A
		SHEET 1 OF 2
		SCALE 1:2
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# FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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[illegible]

Measured by: <i>MM</i>	Audited by: <i>and</i>	Prototype Approval:
Date: <i>07/02/17</i>	Date: <i>07/02/17</i>	Date:

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	